



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE332A94-3400-03-21

Job Sheet 199370



Part No: RBE332A94-3400-03-21

Job Qty: 3 pcs

Part Name: Target Block 1 User



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/21/19

Job Tracking No:

Due Date: 11/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S224166



Part: RBE332A94-3400-03-21

Job No: 199370

Serial No/Batch: S224166

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/16/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - 1	3 pcs	11/22/19		0.00	0.60	Small Fab - 1	MHL
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	
110	QC 5	3 pcs	11/22/19		0.00	0.00	QC 5 - 10	DAS OCT 22 2019 9-89
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	3 pcs	11/22/19		0.00	0.00	Packaging 3 - 1 - B4B	DAS 28 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - SA	3 pcs	11/22/19		0.00	0.00	QC 21 - SA - 21	DAS 21 9-89 OCT 25 2019
							QC 21 - SA - 70	
							QC 21 - SA - 53	

Part Op 100 - 1-Do NOT remove clear protective film prior to assembly. 2-Assemble as per DWG. See note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

GAI/HOB

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 70 40 1408 134 90591A171	Hex Nut	9 Ea (3 ea)	100-Small Fab - 1	FM138414-2
91280A640	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.50 mm X 45 mm LG.	9 Ea (3 ea)	100-Small Fab - 1	3216728
98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	9 Ea (3 ea)	100-Small Fab - 1	3157242
RBE332A94-3400-03-22 Base		3 pcs (1 ea)	100-Small Fab - 1	3165296
RBE332A94-3400-03-23 Standoff		9 pcs (3 ea)	100-Small Fab - 1	3219892

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	9	64	0
	91280A640	9	13	0
	98023A031	9	64	0
	RBE332A94-3400-03-22	3	3	0
	RBE332A94-3400-03-23	9	0	0

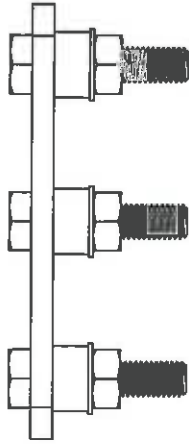
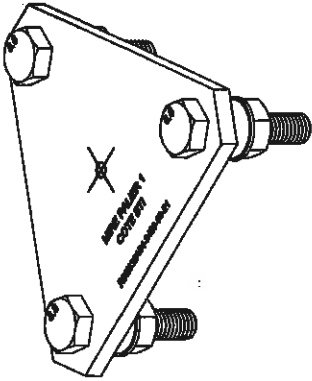
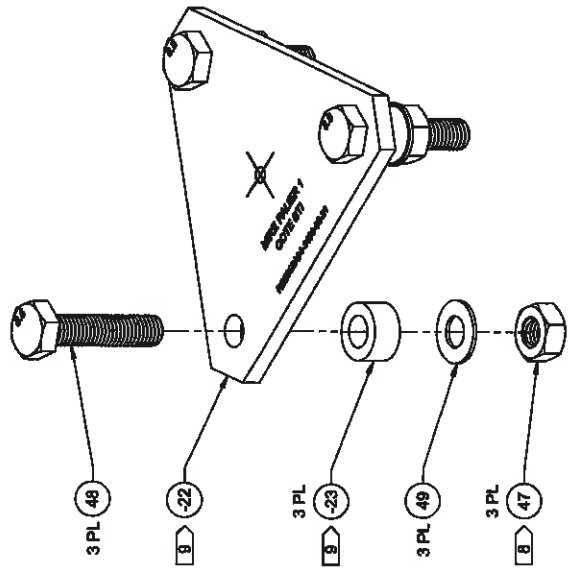
Part Specifications

Specifications could not be found.

Plex 8/21/19 8:00 AM Dart.lajeunesse.marie

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-22	1	RBE332A94-3400-03-22	BASE
-23	3	RBE332A94-3400-03-23	STANDOFF
47	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
48	3	McMaster#91280A640 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.50 mm X 45 mm LG.
49	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051" - 0.080" THK.



RBE332A94-3400-03-21 TARGET BLOCK 1 USER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199370 M05
190821

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X X = $\pm 0.1"$ / $\pm 1"$
X XX = $\pm 0.01"$ / $\pm 0.5"$
X XXX = $\pm 0.005"$ / $\pm 0.1"$
X XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) INSTALL ITEM 47 HAND TIGHT
 - 9) ALIGN ITEM -22 AND -23 THEN APPLY LOCTITE 496 BETWEEN THE SURFACES, AND REMOVE EXCESS
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	REV. A
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	
INSTR. APPL.	DP	RBE332A94-3400-03	SHEET 22 OF 28
APPROVED	WY	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
		DATE 2/14/2019	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date : _____		Sequence #: _____		QTY Affected : _____																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details: _____		Completed By _____																															
Lead hand / Supervisor _____		QC / QA Coordinator _____																															

MRB (QSI042)